

Date: Tuesday, 05/06/2007 1:45:24 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L/L 1/L3 SCUFF PLATE, FWD LH
 Job Number : 32753
 Estimate Number : 12268
 P.O. Number : *N/A* Part Number : D206555005
 This Issue : 05/06/2007 S.O. No. : *N/A* Drawing Number : D206-555 REV C
 Prsht Rev. : NC Project Number : *N/A*
 First Issue : *N/A* Type : SMALL/MED FAB Drawing Revision : C
 Previous Run : 31184 Material : *N/A*
 Due Date : 12/06/2007 Qty: 2 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est C 99.06.29 Returned to Electro Polish DM
 Est Rev:D Now On Waterjet 07-01-22 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Type Labels as per PPP D206-555-005

2.0 M304S25GA 304/316 .020" Sheet



Comment: Qty.: 0.4610 sf(s)/Unit Total: 0.9220 sf(s)
 304/316 .020" Sheet
 Batch: *M 103504*

3.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D206-555
 Dwg Rev: *C*
 Prog Rev: *C*
 2-Deburr if necessary

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

see w/lo 31605
for MM 07-06-02

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

see w/lo 31605
for SD 07-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT 8318-5

Finish form on bench forming Jig DT 8319-5

SD 07/08/06 (2)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

See 06-07 (2)

8.0 OUTSIDE SERV.20 OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 3923

Possible supplier: TQF Technologies

07/06/07 (2)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

07/06/18 (2)

10.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

En 07/06/20 (2)

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

N/A

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: W Date: 07/06/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D206555005

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10/4/26 (2)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/6/26 (2)

Job Completion



10/8/26



Certificat de Conformité / Certificate of Compliance

ATO: Dart Aerospace Ltd.

Date: June 15, 2007

1270 Aberdeen St

Hawkesbury, Ontario

No. de certificat
Certification No.

K6A 1K7

tel.: (613) 632-5200

fax: (613) 632-1053

C117012

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
127963		NO. DE COM./P.O.# 3923	ELECTROPOLISH PER ASTM B912 REV.02
	8	D206-555-006 B31605	
	2	D206-555-005 B32753	

Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et specifications et sont en accord avec les exigences ci-inclus.

We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.

Signé pour et au nom de TQF Technologies Inc.
Signed for and on behalf of TQF Technologies Inc.

G. Persaud / G. McPhee

AEROSPACE LTD.

Work Order: 31605

Description: 206 L/L/L3 Scuff Plate, FWD RH

Part Number: D206-555-006

Inspection Dwg: D206-555 Rev: C

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST




First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 13.3	+/-0.100	13.3	✓		Measuring tape	
B 8.000	+/-0.010	8.000	✓		Measuring tape	
C 2.7	+/-0.100	2.702	✓		Vern	
D ϕ 0.187	+0.005-0.001	0.189	✓		Vern	
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
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S						
T						
U						
V						
W						
X						
Y						

Measured by: ml ml

Audited by: 

Prototype Approval:

N/A

Date: 07.06.02

Date: 07.06.04

Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	